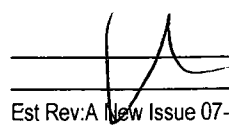
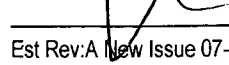


Date: Tuesday, 01/05/2007 2:19:47 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 31868		
Estimate Number	: 12687		
P.O. Number	: <i>N/A</i>	Part Number	: D35711
This Issue	: 01/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3571 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 31868	Material	: <i>N/A</i>
Written By	: 	Due Date	: 14/05/2007
Checked & Approved By	: 	Qty:	80 Um: Each
Comment	: Est Rev:A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
-----	--------------------	-------------------------

*M100157 X 5 pcs*

Comment: Qty.: 0.2531 f(s)/Unit Total: 20.2440 f(s)
 6061-T6 Bar .75" X 1.5"

*M103156 X 8 pcs*Batch: *M104326 X 68 pcs**J.F. 07/05/05*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 2.90" long

J.F. 07/05/07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: *AA* & Dwg D3571 Rev: *A*

2-Deburr per dwg D3571

JL/J.F. 07/05/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/J.F. 07/05/07

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 C'SINK PARTS AS PER DWG D3571

N/A
J.F. 07-05-03

Date: Tuesday, 01/05/2007 2:19:47 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 31868

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/05/08 81

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07/05/10

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

MS 07-05-11 81

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/5/14 59

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: ST 249

7/5/14 50 81

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/05/15

Job Completion



U 07.05.15

Date: Tuesday, 4/17/2007 11:13:46 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 31868	
Estimate Number : 12687	
P.O. Number :	Part Number : D35711
This Issue : 4/17/2007 S.O. No. :	Drawing Number : D3571 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : U/R
Previous Run : 30588	Material :
Written By :	Due Date : 5/12/2007 Qty: 80 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-02-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.2531 f(s)/Unit Total: 20.2440 f(s)
6061-T6 Bar .75" X 1.5"
Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 2.90 " long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: _____ & Dwg D3571 Rev: _____

2-Deburr per dwg D3571

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
C'SINK PARTS AS PER DWG D3571

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 31868

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

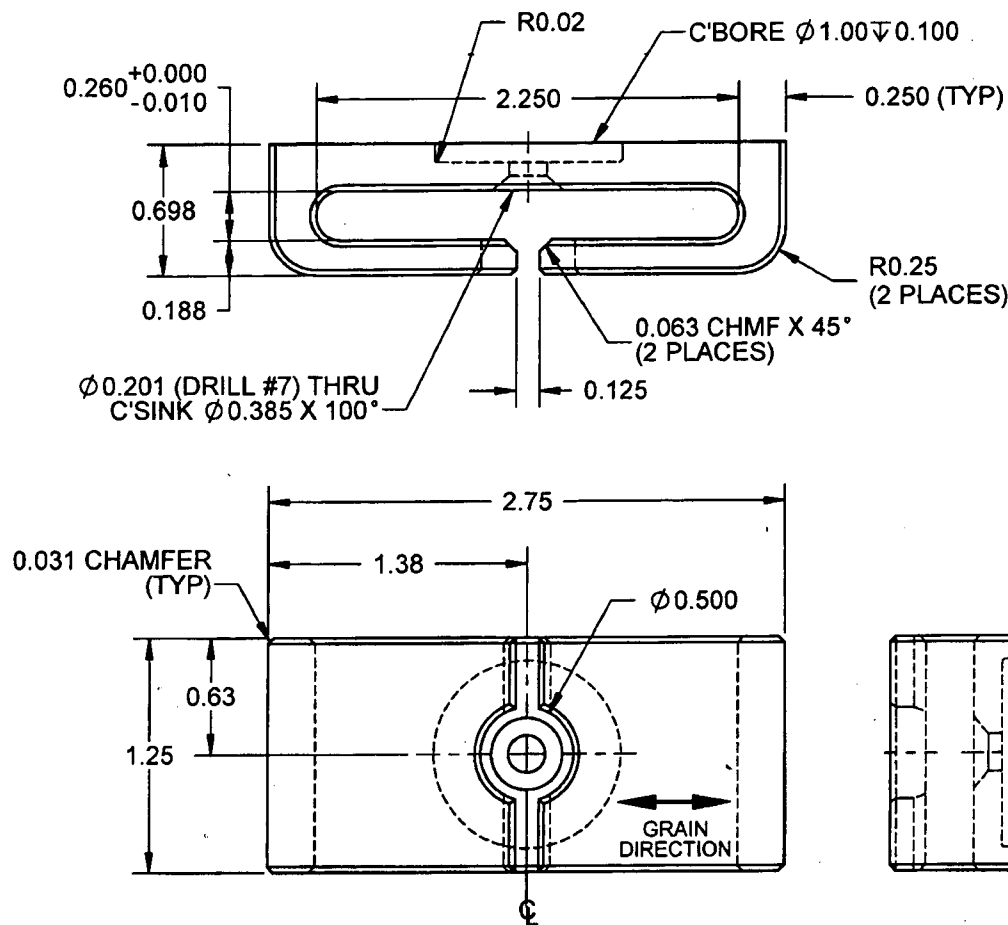
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07-04-12 *[Signature]***D3571-1 GUIDE**

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WORK ORDER
31868

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

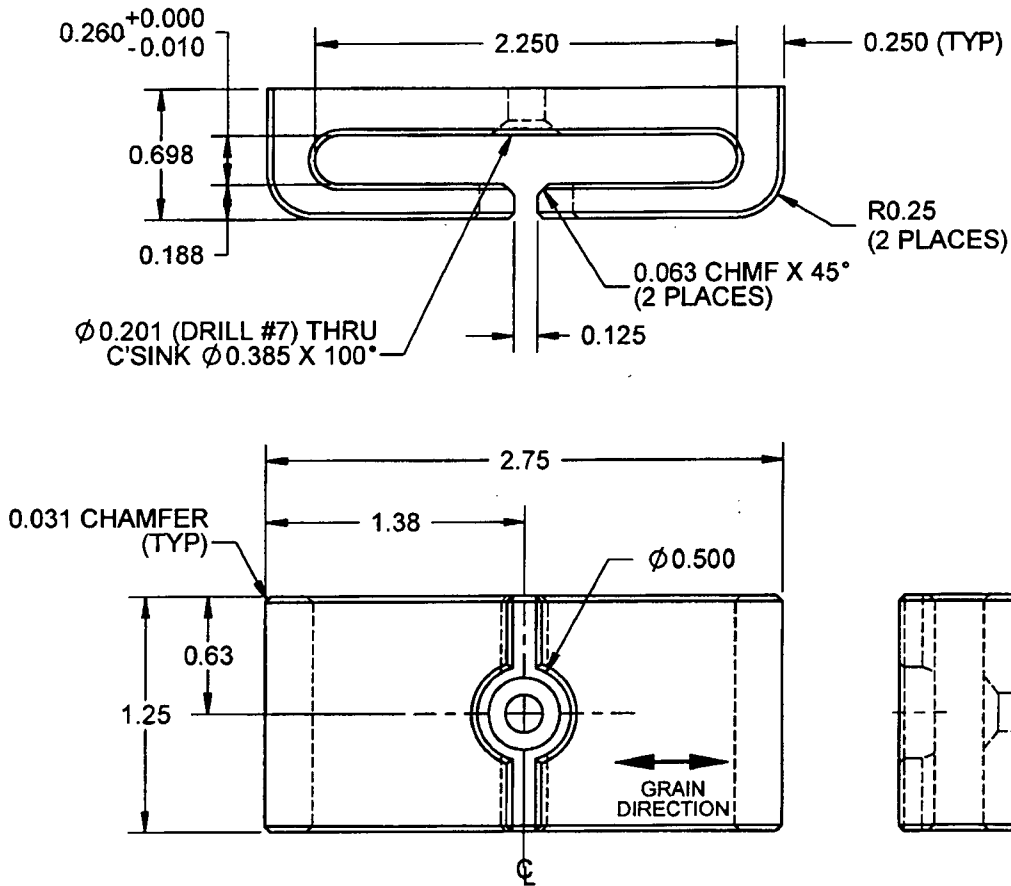
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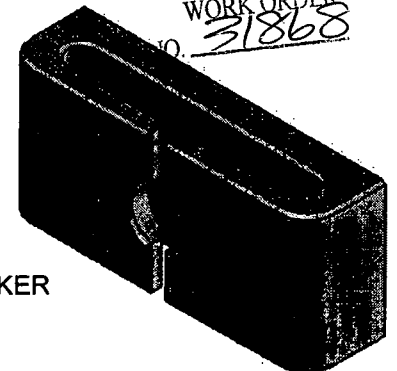
DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1

RELEASED
07.04.12 *[Signature]*

**D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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WORK ORDER
31868

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DART AEROSPACE LTD		Work Order: 31868
Description:		Part Number: 3571-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.260"	+0.008" -0.010"	.260"	✓			
R0.02"	±0.030"	R0.020"	✓			
2.250"	±0.010"	2.241"	✓			
Ø1.00"	±0.030"	Ø.997"	✓			
↓.100"	±0.010"	↓.100"	✓			
.250"	±0.010"	.254"	✓			
.698"	±0.010"	.698"	✓			
.188"	±0.010"	.188"	✓			
Ø.201	+0.005 -0.001	Ø.201"	✓			
C sin K Ø.385x10°	±0.010"	Ø.385x10°	✓			
.125"	±0.010"	.125"	✓			
2.75"	±0.030"	2.751"	✓			
1.38"	±0.030"	1.38"	✓			
Ø.500"	+0.006" -0.001"	Ø.501"	✓			
.63"	±0.030"	.630"	✓			
1.25	±0.030"	1.250"	✓			
.063"x45°	±0.010"	.063"x45°	✓			
.031"x45°	±0.010"	.025"x45°	✓			

Measured by: J.F.	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 07/05/05	Date: 07/05/05	Date: 7/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	